

Work Order ID 51821

September 4, 2009 8:38:30 AM



Page 1

Item ID: D3847-045 *GY*
Revision ID: B
Item Name: CENTER WEARPLATE ASSY, STD/FLOAT

Accept



Setup Start



Stop



Start Date: 09/04/2009 Start Qty: 6.00
Required Date: 09/11/2009 Req'd Qty: 6.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: *MF* Date: *09-09-04* Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3847	B								
100		0.00							
	Waterjet								
FLOW CNC Waterjet	<i>304</i> <i>050</i>								
	Memo	0.00							
	1-Cut as per Dwg D3847								
	Dwg Rev: <i>B</i>								
	Prog Rev: <i>B</i>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC								
Quality Control	Memo	0.00							

HB 9-9-04

6

HB 9-9-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 51821

September 4, 2009 8:38:30 AM



Page 3

Item ID: D3847-045

Accept



Setup Start



Revision ID: B

Stop



Item Name: CENTER WEARPLATE ASSY, STD/FLOAT

Start Date: 09/04/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 09/11/2009 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

M109091

= 111

09/09/29

(X6)

Ø

Powder Coating

START: 9:00am

0.00

TEMP: 320°F

FIN: 9:30am

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

09-09-29

(2)

170

0.00



Small Fab

Memo

0.00

Small Fab

1- Bond gasket to inner surface of wearplate using a thin layer of 3m 1300/1300L scotch grip adhesive as per dwg D3847

BATCH: M111 428

09/10/05 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

September 4, 2009 8:38:30 AM

Page 1

Work Order ID: 51821

Parent Item: D3847-045RevB

Parent Item Name: CENTER WEARPLATE ASSY, STD/FLOAT



Start Date: 09/04/2009

Required Date: 09/11/2009

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3846-5RevB 		Manufactured	No				Each	0.0000	6.0000			
GASKET M304S18GA 		Purchased	No				sf	183.4395	0.6133			
304/316 .050 Sheet												

B51828

09/10/09

B99-24

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

183.4395053

108156

0.98526316

111743

23.7174

112178

158.736842

11278

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: S1821
Description: CENTER WEARPLATE ASSY STD/FLOAT GEAR		Part Number: D3847-45
Inspection Dwg: D3847-5 Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

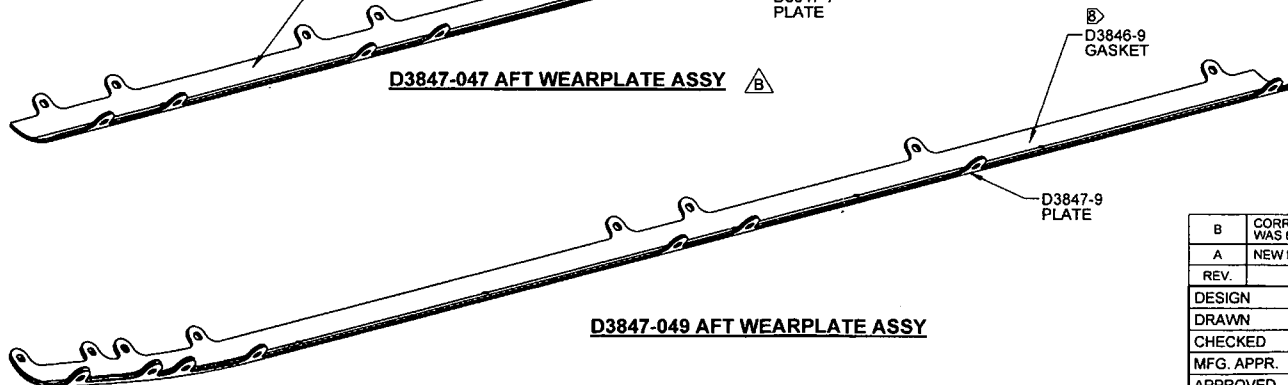
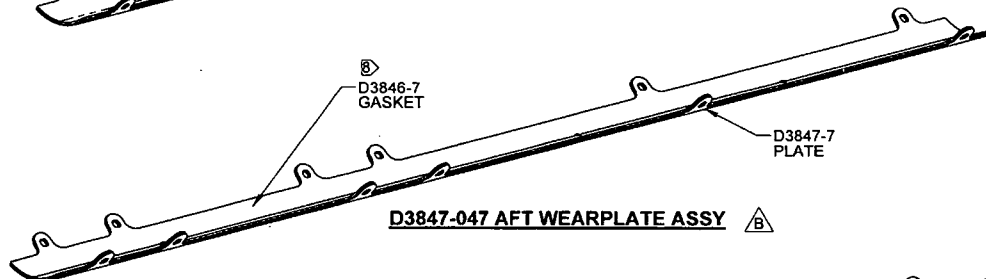
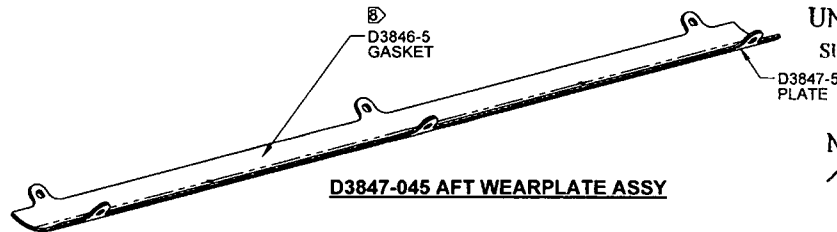
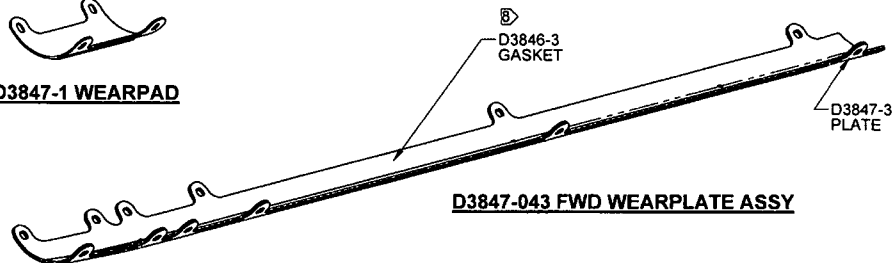
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .188	+.005 - .001	.192	*			
.300	± .010	.307	*			
.300	± .010	.305	*			
2.45	± .030	2.444	*			
3.280	± .010	3.278	✓			
4.13	± .030	4.114	*			
1.69	± .030	1.693	✓			
8.49	± .030	8.480	✗			
18.000	± .010	18.000	✓			
34.98	± .030	34.98	✓			
.75	± .030	.747	*			
15.863	± .010	15.800	✗			
31.606	± .010	31.606	✓			
.050	± .010	.047	*			

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 9-9-24	Date: 09/09/25	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

D3847-1 WEARPAD



RELEASED
09/07/15

ITEM	QTY -043	QTY -045	QTY -047	QTY -049	P/N	DESCRIPTION
1	X				D3847-043	FWD WEARPLATE ASSY, STD/FLOAT GEAR
2		X			D3847-045	CENTER WEARPLATE ASSY, STD/FLOAT GEAR
3			X		D3847-047	AFT WEARPLATE ASSY, STD GEAR
4				X	D3847-049	AFT WEARPLATE ASSY, FLOAT GEAR
11	1				D3847-3	PLATE
12		1			D3847-5	PLATE
13			1		D3847-7	PLATE
14				1	D3847-9	PLATE
15	1				D3846-3	GASKET
16		1			D3846-5	GASKET
17			1		D3846-7	GASKET
18				1	D3846-9	GASKET
31	A/R	A/R	A/R	A/R	1300 (OR 1300L)	3M SCOTCH-GRIP ADHESIVE

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. 51821

MF 09-09-04

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3847-XXX" USING YELLOW PAINT MARKER AT INSIDE SURFACE
 - 7) WEIGHT: D3847-043 = 1.71 lbs
D3847-045 = 1.49 lbs
D3847-047 = 2.00 lbs
D3847-049 = 4.21 lbs
 - 8) BOND D3846-X GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

B	CORRECT TYPO D3847-047 WAS D3847-045. ZN B5-1; 5.82 WAS 6.25 (ZN A4-2); 43.28 WAS 45.71 (ZN B4-5)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	RF		
MFG. APPR.	RF		
APPROVED	RF		
DE APPR.	RF		
DATE	09.06.30		

DART AEROSPACE USA, INC.
PORT HADLOCK, WA

DRAWING NO. **D3847** REV. B
SHEET 1 OF 7
TITLE **WEARPLATE ASSY** SCALE NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

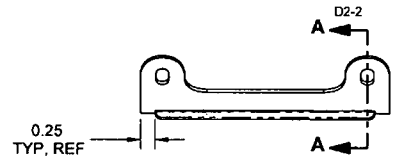
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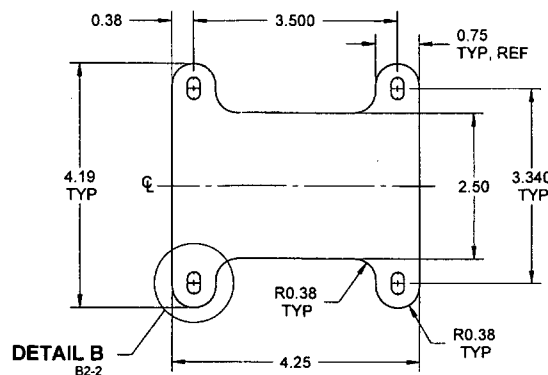
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

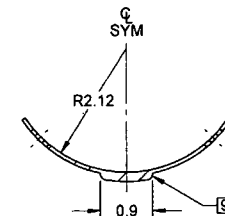
51821



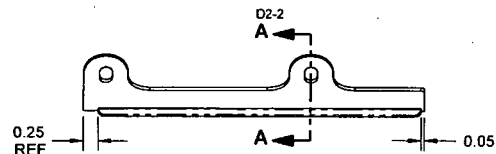
D3847-1 WEARPAD
MADE FROM D3847-1F FLAT PATTERN



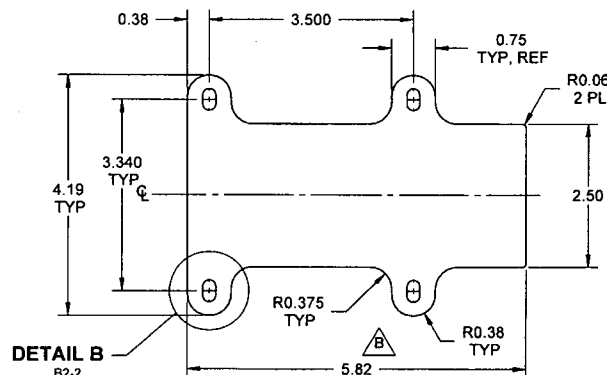
D3847-1F FLAT PATTERN



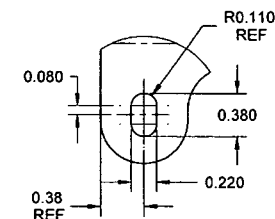
SECTION A-A D7-2 B7-2



D3847-11 WEARPAD
MADE FROM D3847-11F FLAT PATTERN



D3847-11F FLAT PATTERN



DETAIL B C5-2 B5-2
TYP, SCALE 2X

RELEASED
12/15/10

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK), (REF. DART SPEC. M304S16GA)
- 2) FINISH: POWDER COAT "GREY SANDEK" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3847-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT:
D3847-1 = 0.03 lbs
D3847-11 = 0.47 lbs
- 8) WELD PER QSI 004
- 9) APPLY 2 LAYERS OF 2059B HARDCOAT WELDS TO WITHIN 0.25 OF WEARPAD ENDS 0.19 TO 0.25 THICK UNLESS OTHERWISE INDICATED

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO. D3847	REV. B
MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 7	
APPROVED		TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEARPLATE ASSY	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

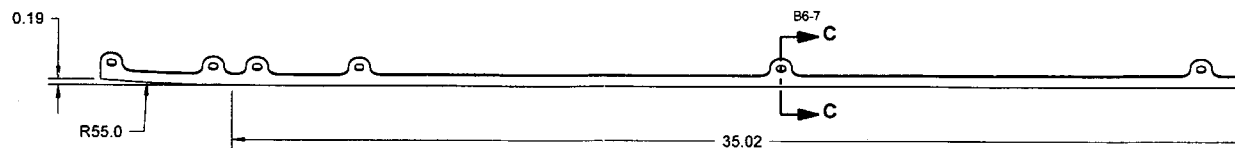
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

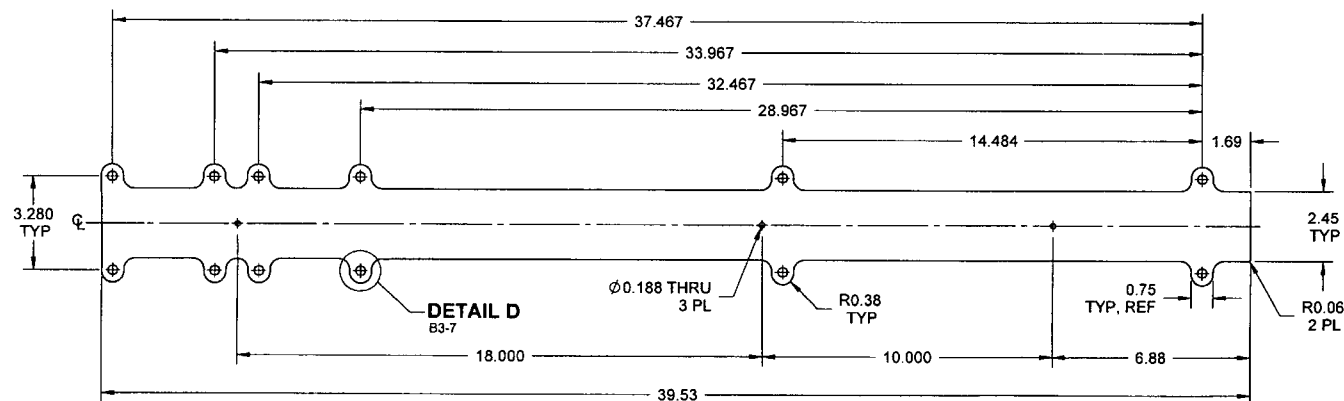
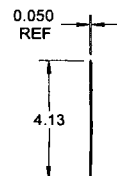
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

51821



D3847-3 PLATE
MADE FROM D3847-3F FLAT PATTERN



D3847-3F FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER AMS 5513 OR AMS 5524, 18 GAUGE (0.050 THICK), (REF. DART SPEC. M304S18GA)
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.46 lbs

RELEASED
29/07/13

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	<i>PH</i>	DRAWING NO. D3847	REV. B
MFG. APPR.	<i>E</i>	SHEET 3 OF 7	
APPROVED		TITLE	SCALE
DE APPR.	<i>H</i>	WEARPLATE ASSY	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

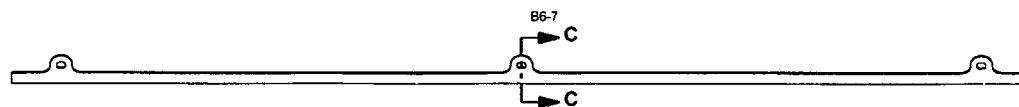
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

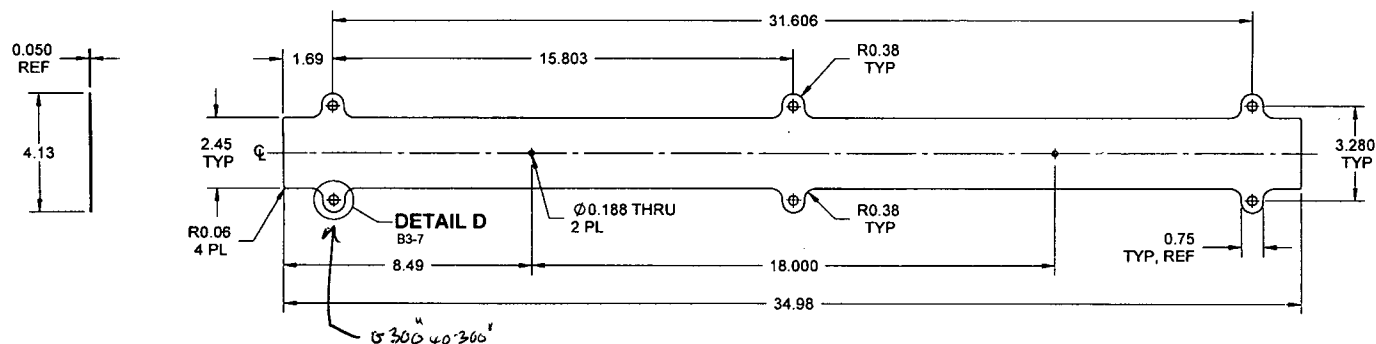
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

51521



D3847-5 PLATE
MADE FROM D3847-5F FLAT PATTERN



D3847-5F FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER AMS 5513 OR AMS 5524, 18 GAUGE (0.050 THICK), (REF. DART SPEC. M304S18GA)
- 2) FINISH: POWDER COAT "GREY SANDEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.29 lbs

RELEASED
9/6/15

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	<i>RF</i>	DRAWING NO. D3847	REV. B
MFG. APPR.	<i>RF</i>	TITLE	SHEET 4 OF 7
APPROVED	<i>RF</i>	WEARPLATE ASSY	SCALE
DE APPR.	<i>RF</i>	DATE	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O 51921

D3847-7 PLATE
MADE FROM D3847-7F FLAT PATTERN

D3847-7F FLAT PATTERN

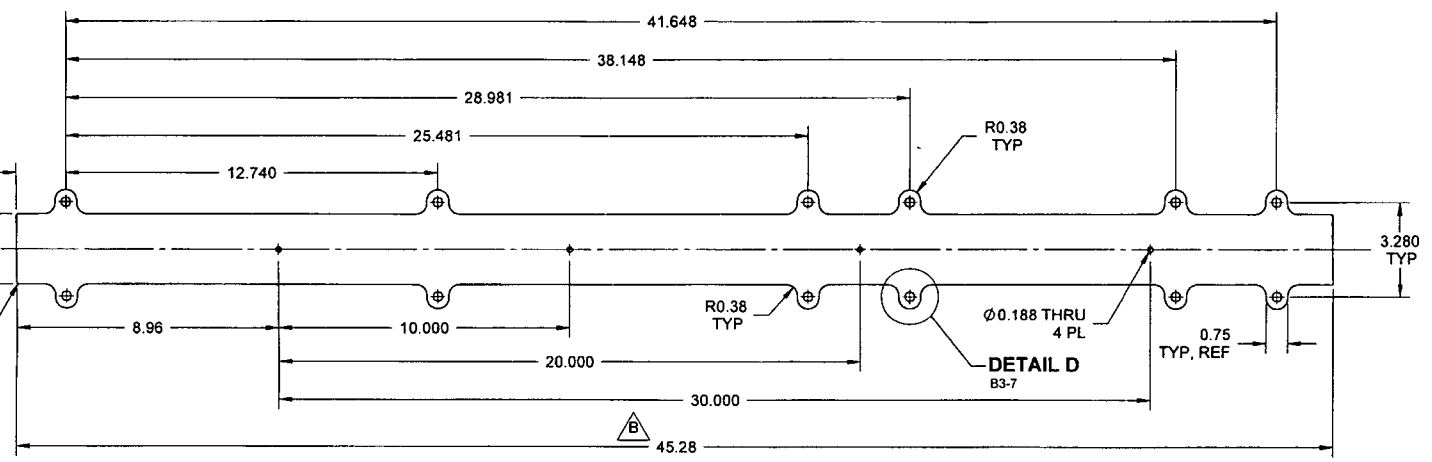
0.050
REF

4.13

1.69

2.45
TYP

R0.06
4 PL



NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER AMS 5513 OR AMS 5524, 18 GAUGE (0.050 THICK), (REF. DART SPEC. M304S18GA)
- 2) FINISH: POWDER COAT "GREY SANDEXT" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.70 lbs

RELEASED
8/6/10

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	C	D3847	SHEET 5 OF 7
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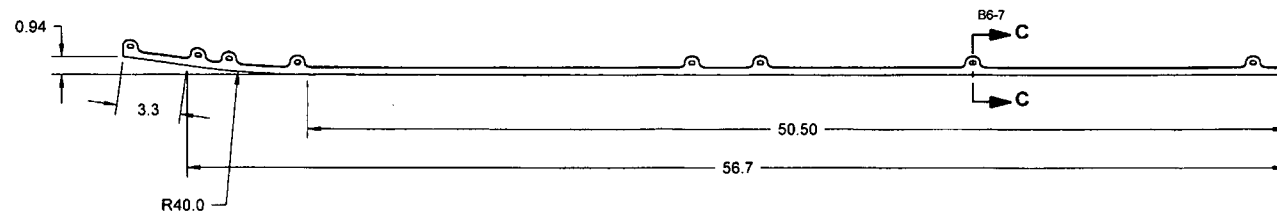
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

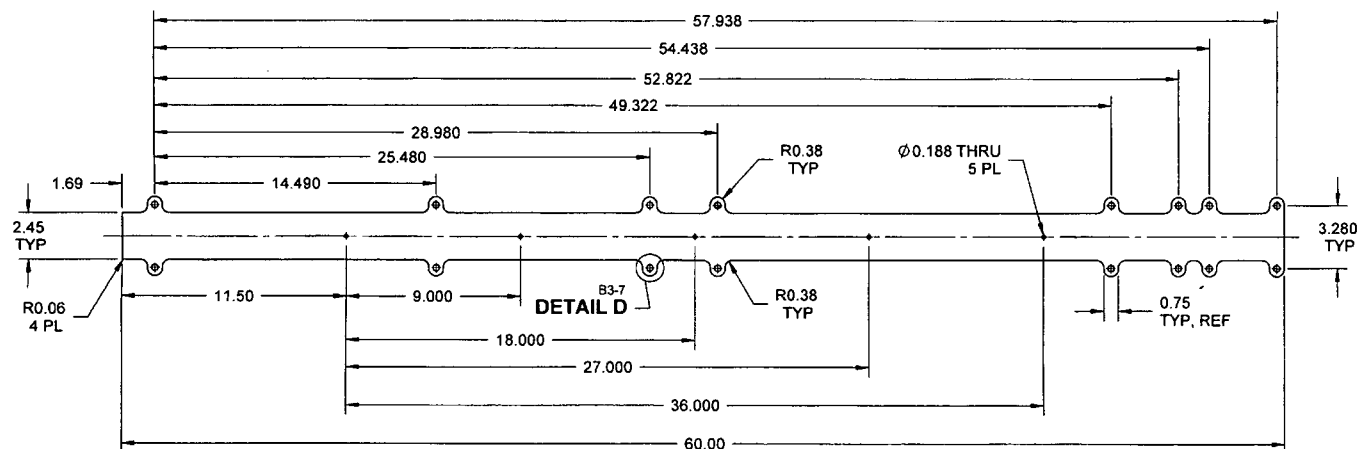
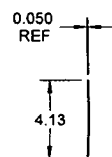
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O 51821



D3847-9 PLATE
MADE FROM D3847-9F FLAT PATTERN



D3847-9F FLAT PATTERN

RELEASED
09/06/30

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER AMS 5513 OR AMS 5524, 18 GAUGE (0.050 THICK), (REF. DART SPEC. M304S18GA)
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 3.86 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	AB	DRAWING NO. D3847	REV. B
MFG. APPR.	E	SHEET 6 OF 7	
APPROVED		TITLE	SCALE
DE APPR.	#	WEARPLATE ASSY	NTS
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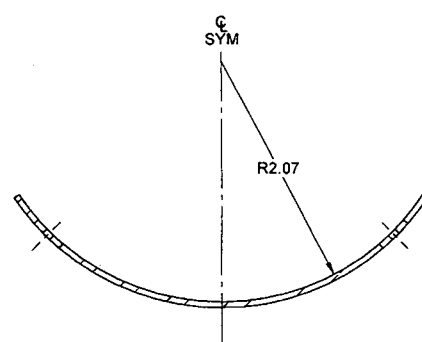
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

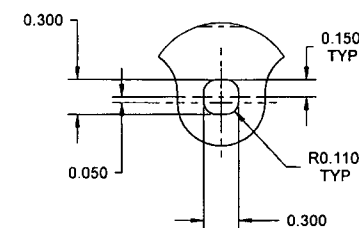
NOTE: Date & initial all entries

w/o 31821



SECTION C-C
SCALE 4X

D4-3
D4-4
D3-5
D3-6



DETAIL D
TYP, SCALE 4X

B5-3
B6-4
B3-5
B5-6

RELEASED
09/07/15

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3847	SHEET 7 OF 7
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries